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647.1402

Job Sheet 186701



Part No: 647.1402

Job Qty: 2 ea

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.1402 REV D IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

6620

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/7/18	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	2 pcs		12/7/18	0.00	0.00	Packaging1-1		
120	Small Fab	2 pcs		12/7/18	0.00	1.00	Small Fab-1		
130	QC	2 pcs		12/7/18	0.00	0.00	QC5		
140	Packaging	2 pcs		12/7/18	0.00	0.00	Packaging3-1		
150	QC21-SA	2 Ea		12/7/18	0.00	0.00	QC21		

Part Op 120 - Assemble as per dwg and apply locite 598 on all faying surfaces per note 2.
Descriptions: 140 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

DAS
NOV 28 2018
NOV 29 2018
NOV 29 2018
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.9701	Cutter Sub Assembly	2 Ea (1 ea)	90-Start up Operation	5127113
647.1501	Lower Deflector Assembly	2 Ea (1 ea)	90-Start up Operation	5119589
MS21042L08	Nut	6 Ea (3 ea)	90-Start up Operation	5100409
MS27039-08-19	Screw	6 Ea (3 ea)	90-Start up Operation	5104359
NAS1149FN832P	Washer	12 Ea (6 ea)	90-Start up Operation	5107796

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	646.9701	2	14	0
	647.1501	2	4	0
	MS21042L08	6	1,084	0
	MS27039-08-19	6	1,246	0
	NAS1149FN832P	12	1,511	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																	
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																	
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																	
Large Fab ☐	Composite ☐	Supplier ☐																		
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition																		

Container No: S130528
 Part: 647.1402
 Job No: 186701
 Serial No/Batch: S130528
 Revision: D
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 11/22/18

Root Cause							
Environment ☐	No Re-verification ☐	Pressure/ ☐					
Design ☐	Operator ☐	Bending ☐					
Doc/Data ☐	Offset/Setup ☐	Centre No ☐					
Equip/Tooling ☐	Supplier ☐	Cracks ☐					
Handling/Pre ☐	Training ☐	Crimp/Kinl ☐					
Material ☐	Use for Testing ☐	Cuffs ☐					
Internal Transport ☐	Poor Information ☐	Crushing ☐					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐					
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						
		OTHER : _____					